

Work Order ID 85198

June-04-12 1:33:56 PM

85198

Page 1

Item ID: D4079-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp Half, Attachment

Start Date: 04/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/04 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4079

B

100

0.00

100

Bandsaw

Memo

0.00

12-06-06

12

Jeaspa Bandsaw

Cut blank 2.750" long

110

0.00

110

HAAS 1

Memo

0.00

12 06 09 12

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA931

Folio rev: AA

Dwg Rev: B

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85198

85198

Page 2

June-04-12 1:33:56 PM

Item ID: D4079-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp Half, Attachment

Start Date: 04/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12-06-09 (X12)

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

12/06/11

12 X

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

12 NG 12-6-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85198

June-04-12 1:33:56 PM

85198

Page 3

Item ID: D4079-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp Half, Attachment

Start Date: 04/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

Start Time: 2:10
Temp: 320°F
Finish Time: 2:40

12X

0

mk
12/06/11

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12

0

BR 126-11

170

Identify as per dwg & Stock Location: 5691

0.00

170

Packaging

Memo

0.00

Packaging

12

0

Sub 12/06/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85198

85198

Page 4

June-04-12 1:33:56 PM

Item ID: D4079-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp Half, Attachment

Start Date: 04/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/12

12-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-04-12 1:34:00 PM

Page 1

Work Order ID: 85198

85198

Parent Item: D4079-1

D4079-1

Parent Item Name: Clamp Half, Attachment

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	15.1670	0.23	2.905263			

M6061T6B2 000X02 000

**

SL 12-06-06

6061-T6 Bar 2.00 x 2.00

Location

Loc Qty

Loc Code

MAT009

15.167

113123

1.977

119801

12

13085

1.19

2.91

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	85198
Description: Clamp Half, Attachment		Part Number:	D4079-1
Inspection Dwg: D4079	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.502	+/-0.010	2.503	✓		vern	RT-4
Ø0.203	+0.005/-0.001	.206	✓		"	
0.75	+/-0.030	.749	✓		"	
0.375	+/-0.010	.375	✓		"	
0.310	+/-0.010	.306	✓		"	
1.882	+/-0.010	1.881	✓		"	
0.78	+/-0.030	.779	✓		"	
R0.13	+/-0.030	.130	✓		rad gauge	
1.440	+/-0.010	1.443	✓		vern	RT-4
R0.38	+0.010/-0.000	.384	✓		hight gauge	RT-6
R0.050	+/-0.010	.05	✓		rad gauge	
R0.73	+/-0.030	.727	✓		vern	RT-4
Ø0.257	+0.006/-0.001	.256	✓		"	
R0.25	+/-0.030	.250	✓		rad gauge	
0.390	+/-0.010	.389	✓		vern	RT-4
0.850	+/-0.010	.851	✓		hight gauge	RT-6
0.025 x 45°	+/-0.010 x 0.5°	.030	✓		vern	RT-4
0.100	+/-0.010	.102	✓		"	
R0.05	+/-0.030	.062	✓		rad gauge	
1.240	+/-0.010	1.241	✓		vern	RT-4
1.65	+/-0.030	1.649	✓		"	
0.60	+/-0.030	.601	✓		hight gauge	RT-6
0.23	+/-0.030	.225	✓		vern	RT-4
0.025	+/-0.010	.030	✓		"	

Measured by:	RT 1	Audited by:	and	Preliminary Approval:	
Date:	12-06-09	Date:	12/06/10	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	

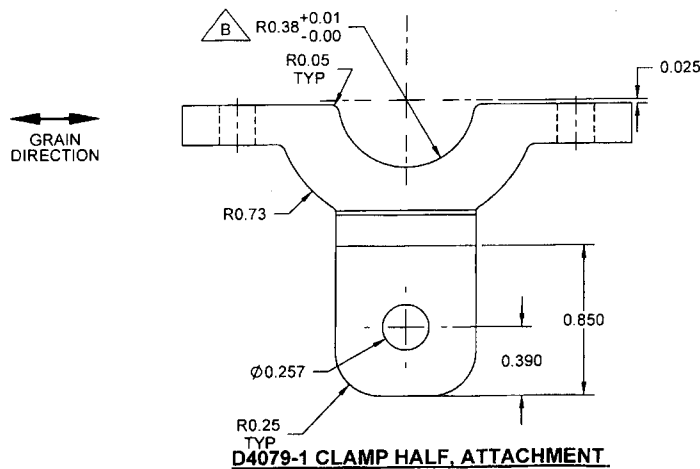
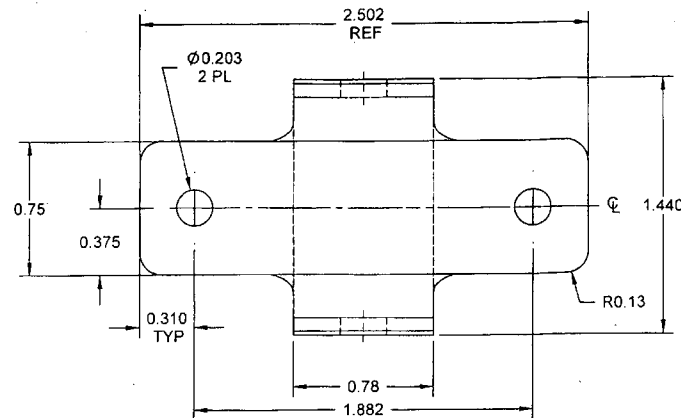
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

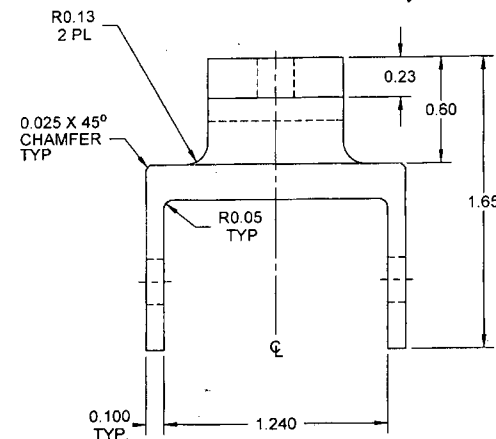
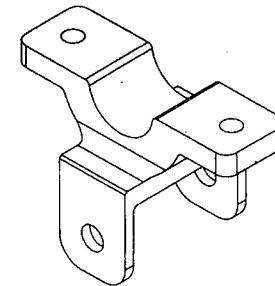
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85198 MLJ
12106104



RELEASED
2010-09-07
MP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4079-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

B	R0.38 WAS R0.48.	VB	10.07.30
A	NEW ISSUE	VB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN		VB	
DRAWN		VB	
CHECKED		VB	
MFG. APPR.		VB	
APPROVED		VB	
DE APPR.		VB	
DATE	10.07.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4079	REV. B
TITLE CLAMP HALF, ATTACHMENT	SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries